



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Split
4/14

D5377-1

Job Sheet 179743



Part No: D5377-1

Job Qty: *4 ea*

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		7/18/18	0.00	0.00	Start Up Waterjet		<i>on 18/06/30</i>
120	Waterjet	8 pcs		7/18/18	0.00	4.65	Waterjet1		<i>on 18/06/30</i>
130	CNC Vertical Machining	8 pcs		7/18/18	0.62	20.51	HAAS1-2		<i>D.A. 18/09/14</i>
140	QC	8 pcs		7/18/18	0.00	0.00	QC2 Machining-4		<i>D.A. 18/09/14</i>
150	QC	8 pcs		7/18/18	0.00	0.00	QC8 Machining-4		<i>mm L 18/09/14</i>
151	Packaging	8 pcs		7/18/18	0.00	0.00	Packaging3	<i>5/4/53</i>	<i>SEP 14 2018</i>
190	QC21-SA	8 Ea		7/18/18	0.00	0.00	QC21		<i>SEP 14 2018</i>

Part Op 120 - Cut Blank as per D5377-1_blank File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB448 and Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	42.4000 sf (5.3 ea)	90-Start up Operation	<i>5045596</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	42	1,376	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.380Inches ± 0.030	0.410 0.350		
2	Bearpaw	5.000Inches ± 0.030	5.030 4.970		
3	Bearpaw	3.930Inches ± 0.030	3.960 3.900		
4	Bearpaw	1.380Inches ± 0.030	1.410 1.350		
5	Bearpaw	5.500Inches ± 0.030	5.530 5.470		
6	Bearpaw	1.720Inches ± 0.030	1.750 1.690		
7	Bearpaw	2.0Degrees ± 0.0	2.0		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description V _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																
			MRB (QSI042) Approval															
			Completed By															
			Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval															

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Container No: S088602
Part: D5377 - 1
Job No: 179743
Serial No/ Batch: S088602
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____

Date: 06/20/18

Root Cause			
Environment	No Re		
Design	Operator		
Doc/Data	Offset/Setup		
Equip/Tooling	Supplier		
Handling/Pre	Training		
Material	Use for Testing		
Internal Transport	Poor Information		
Tribal Knowledge	Rushing		
LOA	Product Improvement		
Substation	Process Improvement		
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due		

Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	Broken/Damaged Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	JSS/Surge Program 3 Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center
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Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

OTHER : _____

			2.0	
8	Bearpaw	15.440Inches ± 0.030	15.470 15.410	
9	Bearpaw	4.688Inches ± 0.010	4.698 4.678	
10	Bearpaw	0.756Inches ± 0.010	0.766 0.746	
11	Bearpaw	0.700Inches ± 0.010	0.710 0.690	
12	Bearpaw	24.000Inches ± 0.030	24.030 23.970	
13	Bearpaw	21.340Inches ± 0.030	21.370 21.310	
14	Bearpaw	6.400Inches ± 0.030	6.430 6.370	
15	Bearpaw	3.520Inches ± 0.030	3.550 3.490	
16	Bearpaw	0.240Inches ± 0.030	0.270 0.210	
17	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius
18	Bearpaw	0.300Inches ± 0.030	0.330 0.270	
19	Bearpaw	45.0Degrees ± 0.5	45.5 44.5	
20	Bearpaw	0.500Inches ± 0.030	0.530 0.470	
21	Bearpaw	0.740Inches ± 0.030	0.770 0.710	
22	Bearpaw	0.950Inches ± 0.030	0.980 0.920	
23	Bearpaw	0.261Inches + 0.006 - 0.001	0.267 0.260	
24	Bearpaw	0.500Inches ± 0.010	0.510 0.490	
25	Bearpaw	0.060Inches ± 0.030	0.090 0.030	
26	Bearpaw	45.0Degrees ± 0.5	45.5 44.5	
27	Bearpaw	0.460Inches ± 0.010	0.470 0.450	
28	Bearpaw	0.650Inches ± 0.010	0.660 0.640	
29	Bearpaw	0.375Inches ± 0.010	0.385 0.365	

Plex 6/21/18 7:45 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

